Work Order ID 112087

January-29-14 9:56:57 AM

112087

Item ID: D4635-4 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Aft Ceiling Panel, RH

Start Date: 30/01/2014 **Start Qty:** 1.00 *1*

Required Date: 24/02/2014 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** [signature] **Date:** 14 01 29 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**: D4635 / E									
100	HAND FINISHING THERMOFORMING	0.00				X1			DL 14/02/01
100 Thermoform	**Memo** Cut Blanks	0.00							
Thermoforming Machine									
105	Dry Material	0.00				X1			DL 14/02/01
105 HandThermo	**Memo** Dry Sheet as per QSI022 POLYCARBONATE	0.00							
Hand Finishing Thermoforming	Temp: 250°F								
	Time IN: 5:00 Am 14/01/31								
	Time OUT: 6:00 am 14/02/01								

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Item ID: D4635-4
Revision ID:
Item Name: Aft Ceiling Panel, RH
Start Date: 30/01/2014 **Start Qty:** 1.00 *1*
Required Date: 24/02/2014 **Req'd Qty:** 1.00 *1*
Reference:

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
110	THERMOFORMING MACHINE					x1			DL 14/02/01
Thermoform	**Memo**	0.00							
Thermoforming Machine	Thermoform as per Dwg. D4635-4 and Folio FTA150								
	Dwg. Rev. E								
	Folio Rev. D								
	Visually inspect for proper formation and texture								
130		0.00							
130	HAND FINISHING THERMOFORMING					x1			BB 14/03/11
Thermoform	**Memo**	0.00							
Thermoforming Machine	Trim to Finished Dimensions								
140	~~QC~~ Inspect dimensions to drawing	0.00	DAS 16 9-89						
140 QC 5	Dimensional Inspection								
Quality Control	**Memo**	0.00	14/03/14						
	Fill out Inspection Sheet Rev A								

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐		
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
Large Fab ☐	Composite ☐	Supplier ☐	☐		

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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- ☐ Crushing
- ☐ Heat Treat
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- ☐ Hardware
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- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
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- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Work Order ID 112087

January-29-14 9:56:57 AM

112087

Item ID: D4635-4
Revision ID:
Item Name: Aft Ceiling Panel, RH
Start Date: 30/01/2014 **Start Qty:** 1.00 *1*
Required Date: 24/02/2014 **Req'd Qty:** 1.00 *1*
Reference:

Accept *N9000040100*

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____
QC: _____ **Date:** _____
Tooling: _____ **Date:** _____
SPC (Y/N): _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo n/a JS	0.00 0.00							
160 *160* Packaging Packaging	Packaging Memo med Fab	0.00 0.00				(1)	SAD 14/03/14		
170 *170* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				MCJ	14-03-14		

MF 14-3-14

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐ Marks/Chatter
☐ Turning Sequence
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General

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☐ Broken/Damage/Defect
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☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

January-29-14 9:57:03 AM

Work Order ID: 112087 *112087*

Parent Item: D4635-4 *D4635-4*

Parent Item Name: Aft Ceiling Panel, RH

Start Date: 30/01/2014 **Required Date:** 24/02/2014

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B Dwg. Update 12/11/08 DL IPP Rev C Dwg. Update 13/07/09 DL IPP Rev. D Dwg, Update, Material Change 13/12/18 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	1,385.760	9.39	10			
MLEXS.093-F6006-07									**				
GE PLASTICS LEXAN SHEET													

Location	Loc Qty	Loc Code
MAT023	1385.76	
114459	229.26	
123105	38	
124501	1118.5	

10 sq ft

14/03/03

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

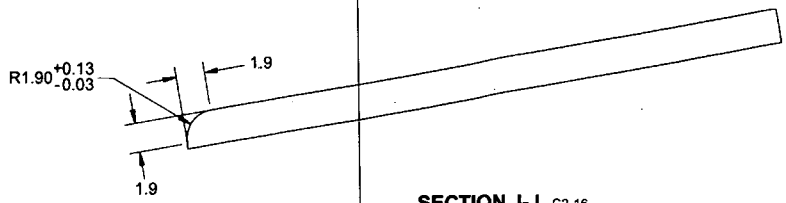
FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
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☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

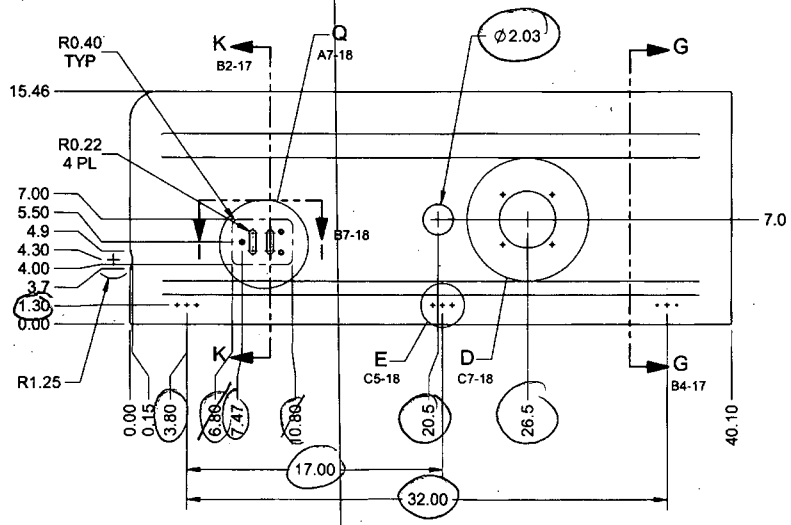
General

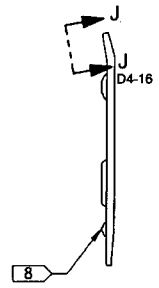
☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
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☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other



SECTION J-J C2-16

112087MP
14-01-29





RELEASED
2014-01-22

D4635-4 RH, AFT CEILING PANEL

NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 2.66 lbs
8) TEXTURE ON THIS SIDE
9) TRIM D4635-4 PER TOOL DT9842
10) THERMOFORM D4635-4 PER QSI 022 USING DT9850 TOOL
MIN. THICKNESS AFTER FORMING:
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	DC	DRAWING NO. D4635 REV. E
MFG. APPR.		SHEET 16 OF 18
APPROVED		TITLE OUTBOARD CEILING PANELS SCALE NTS
DE APPR.		
DATE	14.01.09	

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

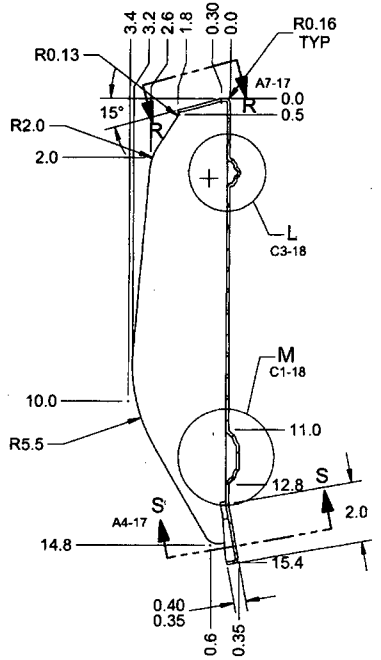
FAULT CATEGORY

Landing Gear

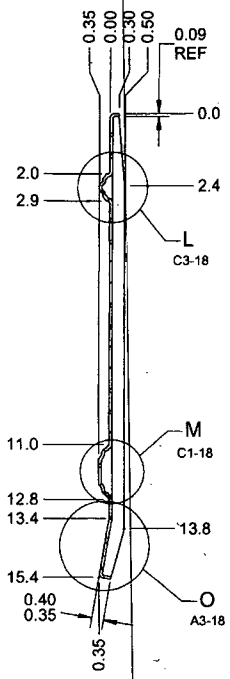
- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

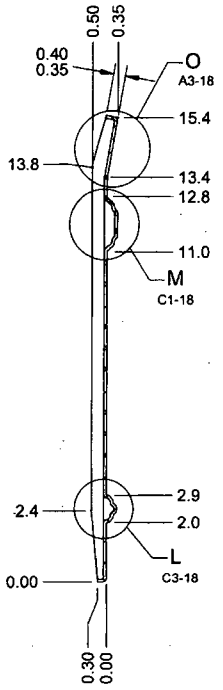
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- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
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- ☐ Cut Too Short
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- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
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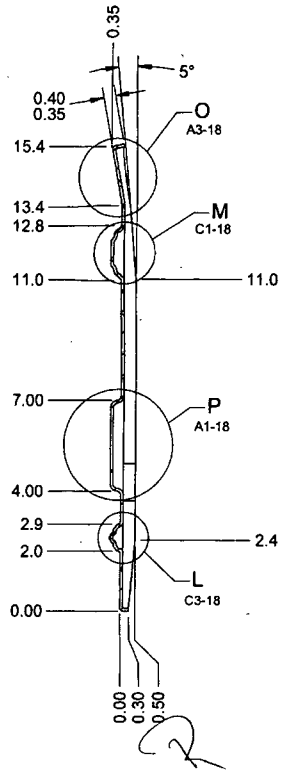
SECTION A-A
SECTION A'-A' OPPOSITE B3-13 B3-14
SCALE 2X



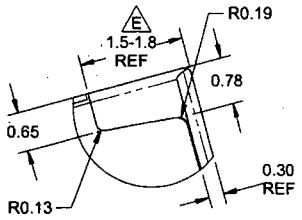
SECTION B-B B7-13 B7-14
SCALE 2X



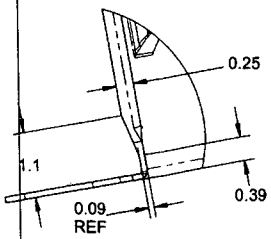
SECTION G-G B4-15 B4-16
SCALE 2X



SECTION K-K C6-16
SCALE 2X



AUXILIARY VIEW R-R D7-17
SECTION R'-R' OPPOSITE
SCALE 2X



AUXILIARY VIEW S-S B7-17
SECTION S'-S' OPPOSITE
SCALE 2X

RELEASED
2014-03-22

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. D4635 REV. E
CHECKED		SHEET 17 OF 18
MFG. APPR.		TITLE OUTBOARD CEILING PANELS
APPROVED		SCALE NTS
DE APPR.		
DATE	14.01.09	

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
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Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

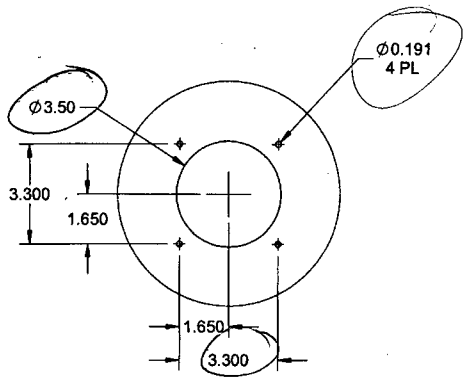
FAULT CATEGORY

Landing Gear

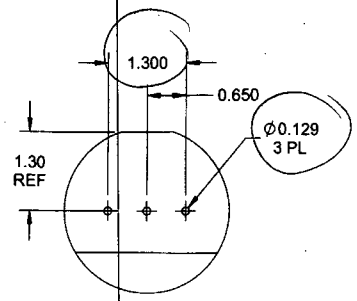
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☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

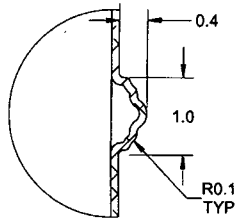
☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other



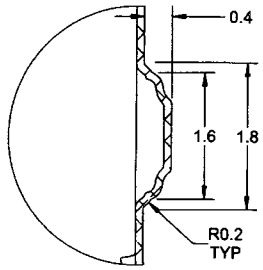
DETAIL D B4-13, B3-14, B5-15, B5-16
SCALE 2X



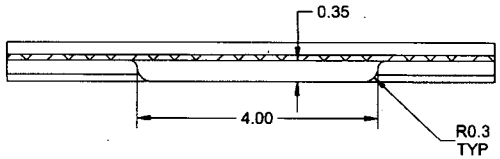
DETAIL E C7-13, B6-14, C6-15, B5-16
SCALE 4X



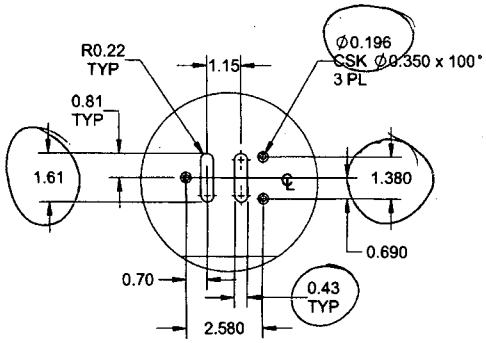
DETAIL L B2-17, B4-17, C5-17, C7-17
SCALE 1.5X



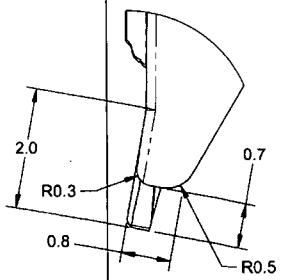
DETAIL M C2-17, C3-17, C5-17, C7-17
SCALE 1.5X



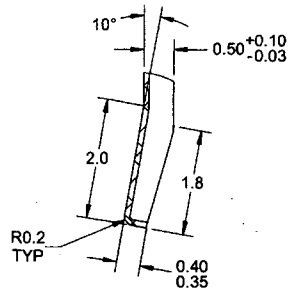
SECTION I-I B5-16
SCALE 4X



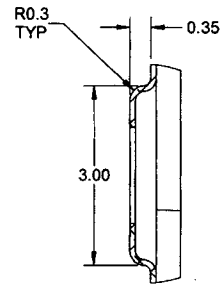
DETAIL Q C5-16
SCALE 2X



DETAIL N B2-13
SCALE 2X



DETAIL O D2-17, D3-17, B5-17
SCALE 2X



DETAIL P C2-17
SCALE 4X

RELEASED
2014 -01- 22

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	PC	DRAWING NO. D4635 REV. E
MFG. APPR.		SHEET 18 OF 18
APPROVED		TITLE OUTBOARD CEILING PANELS SCALE NTS
DE APPR.		
DATE	14.01.09	

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

DART AEROSPACE LTD

Description:	Aft ceiling panel, RH	**Work Order:**	112087
Inspection Drawing:	4635-4	**Rev:**	**Part Number:** D4635-4

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1,300	0,030	1,300	✓		VERN	SFAB-08
3,80	0,030	3,800	✓		tape	SFAB-21
7,47	0,030	7,47	✓		↑	↓
17,00	0,030	17,00	✓			
32,00	0,030	32,00	✓			
20,5	0,100	20,5	✓		↓	↓
26,5	0,100	26,5	✓		TAPE	SFAB-21
Ø 2,03	±0,010	Ø 2,03	✓		VERN	SFAB 08
Ø 3,50	± 0,010	Ø 3,50	✓		↑	↓
3,300	0,0010	3,300	✓			
Ø 0,191	+0,012 -0,001	Ø 0,191	✓		↓	
Ø 0,129	+0,0126 -0,001	Ø 0,129	✓			
1,300	0,0010	1,300	✓		VERN	
1,61	0,030	1,61			↓	
0,43	0,030	0,43	✓			
1,380	0,010	1,380	✓		↓	
Ø 0,196	0,012 -0,001	Ø 0,196	✓		VERN	

Measured by:	Checked By: DAS 16 9-89	QC inspector: DAS 16 9-89	Engineering Approval (*if necessary*):
Date 14-3-13	Date 14/03/14	Date 14/03/14	Date